

Thursday, May 28, 2015 7:58:09 AM

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JUN 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 132776

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Item ID: D044-662-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R44 Bearpaws - Large

Start Date: 4/29/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject/ Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	-------------------	----------------

130

130

Packaging

Packaging

0.00

f604

3

68-61

9

SVD

JUN 08 2015

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D044-662-013
LOCATION: FG014

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MCS

JUN 10 2015

MCS

JUN 09 2015

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OTHER : ☐																									

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132776

D044-662-013

Required Date: 5/7/2015

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-01-30 JLM
IPP Rev:B As per IIN 044-662 REV D 07-03-28 JLM

[illegible]

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OTHER : _____					

Picklist Print

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Work Order ID: 132776

132776

Parent Item: D044-662-013

D044-662-013

Parent Item Name: R44 Bearpaws - Large

Start Date: 4/29/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

D3529-1

DAS

Manufactured No

110

Each

0.0000

2

6

D3529-1

Bearpaw

DAS

AN4-15A

02

Purchased No

110

Each

342.0000

4

12

AN4-15A

Bolt

DAS

6

9-89

DAS

02

9-89

Location

Loc Qty

Loc Code

GA

38

120449

38

ST325A

304

m130358

8

m131320

13

m131957

83

m132317

200

NAS1149D0463J

Purchased

No

110

Each

5,293.000

8

24

NAS1149D0463J

WASHER

DAS

02

9-89

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1817

M132317

1817

ST269

3435

M129682

86

M130799

371

M132035

2978

DAS

27

9-89

DAS

27

9-89

DAS

26

9-89

DAS

26

9-89

DAS

26

9-89

DAS

27

9-89

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132776

Parent Item: D044-662-013

D044-662-013

Parent Item Name: R44 Bearpaws - Large

Start Date: 4/29/2015

Required Date: 5/7/2015

Start Qty: 3.00

Required Qty: 3.00

AN4-14A

Purchased

No

110

Each

365.0000

4

12

AN4-14A

Bolt

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FG	5	
122141	5	
ST325A	294	
131677	2	
M131153	5	
<u>M132189</u>	87	12
M132317	200	
ST344	66	
M130716	15	
M131803	51	

DAS
27
9-89

DAS
20
9-89

MS21042L4

Purchased

No

110

Each

5,511.000

8

24

MS21042L4

Locknut

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001	26	
m124231	26	
GA	216	
m127813	216	
ST260a	4062	
m130799	56	
m131803	6	
m132262	1000	
m132382	3000	
ST305	1207	
m128300	8	
m130388	7	
m130922	97	
m131618	12	
<u>m132123</u>	1083	24

DAS
27
9-89

DAS
20
9-89

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OTHER : _____					

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-662-011 Bearpaw Installation	4.6 lb	0.0 in	0.0 in-lb	128.1 in	589 in-lb
	2.10 kg	0.0 m	0.0 m-kg	3.25 m	6.8 m-kg
D044-662-013 Bearpaw Installation	6.2 lb	0.0 in	0.0 in-lb	129.1 in	800 in-lb
	2.81 kg	0.0 m	0.0 m-kg	3.28 m	9.2 m-kg
D044-662-041 Wearplate Kit (installed on D044-662-011/-013 Bearpaw Kit)*	1.6 lb	0.0 in	0.0 in-lb	128.3 in	205 in-lb
	0.73 kg	0.0 m	0.0 m-kg	3.26 m	2.4 m-kg

*D044-662-041 weight and balance should be added to D044-662-011/-013 kits

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
4	4		D4953-1	Cushion (Replaces D2182B045 Cushion)
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		NAS1149D0463J	Washer (Replaces AN960JD416 Washer)
8	8	4	MS21042L4	Nut (or MS21042-4)